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(54) METHOD OF SHAVING WORK

(57) Abstract:

PURPOSE: To make press capacity small by laminating a front stage die having larger die hole than the die hole of rear stage die on the rear stage die having die hole of the size of outer diameter of a product, and shaving with a punch having outer diameter of the size of rear stage die hole.

CONSTITUTION: A blank 20 is blanked by a die hole of inner diameter D_a which is larger than outer diameter D of a product by shaving allowance. The die hole 10A of the rear stage die 10 is equal to outer diameter of the product, and the size D_c of the die hole 9A of the rear stage die 9 in its upper part is made larger than the die hole 10A and desirably smaller than outer diameter D_a of the blank 20. The size of outer diameter of the punch 11 is a little smaller than the die hole 10A.

By making shaving lowering the shaving punch 11 and dividing into two by die holes 9A and 10A, the large breaking face is removed by one process of a press of small capacity, and the cost is lowered by miniaturizing the die.

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